

Date: Monday, 22/12/2008 3:05:37 PM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ACCESS PANEL ASSEMBLY
Job Number : 44236	
Estimate Number : 12949	
P.O. Number :	Part Number : D3259042
This Issue : 22/12/2008 S.O. No. :	Drawing Number : D3249 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A1
Previous Run : 43641	Material :
Written By :	Due Date : 20/01/2009 Qty: 3/4 Um: Each
Checked & Approved By : <u>JW 08.12.23</u>	
Comment : Est Rev:A New Issue 07-07-19 JLM Verified By:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Pick Assembly Kit

2.0	D32591	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 panel  
 Batch: 43771 3X stone

3.0	D32594	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Doubler  
 Batch: 43773 2X B34282 1X

4.0	D32595	Spacer
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Spacer  
 Batch: 43774

5.0	D32597	Door
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Door  
 Batch: 34738

LO 9/01/23 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/12/2008 3:05:37 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 44236

Part Number: D3259042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D31615

Hinge 9.9"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hinge 9.9"

Batch: 43809

7.0

D32601

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spring

Batch: 43775

8.0

127H5

HALF GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

HALF GROMMET

Batch: M110118

9.0

250018C3Y

RIGHT RECEPTACLE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

RIGHT RECEPTACLE

Batch: 100034

10.0

2501W20020C3Y

STUD



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

STUD

Batch: 100358

11.0

MS20426AD44

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

Batch: M15541

12.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 36.0000 Each(s)/Unit Total : 144.0000 Each(s)

Rivet, Universal Head

Batch: M15541

9/1/23 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 22/12/2008 3:05:37 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 44236

Part Number: D3259042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS20470AD35

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivet

Batch: 7682

LC 9/1/23 (3)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble D3259-041 as per Dwg D3259.  
Note: Keep .040" Gap all around door.

EP 09/01/30 (3)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SO 09/01/30 (3)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify with P/N and B/N using a permanent fine point marker, then Stock  
Location: LC 9/01/30 (3)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/02 J

Job Completion



MF 09-01-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

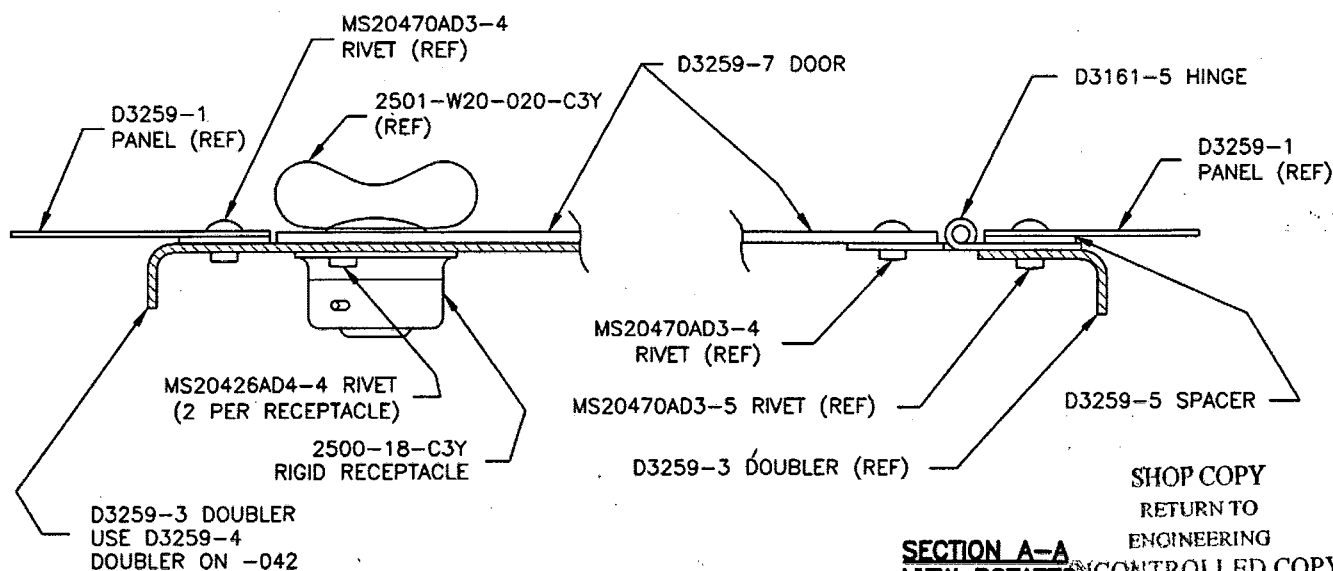
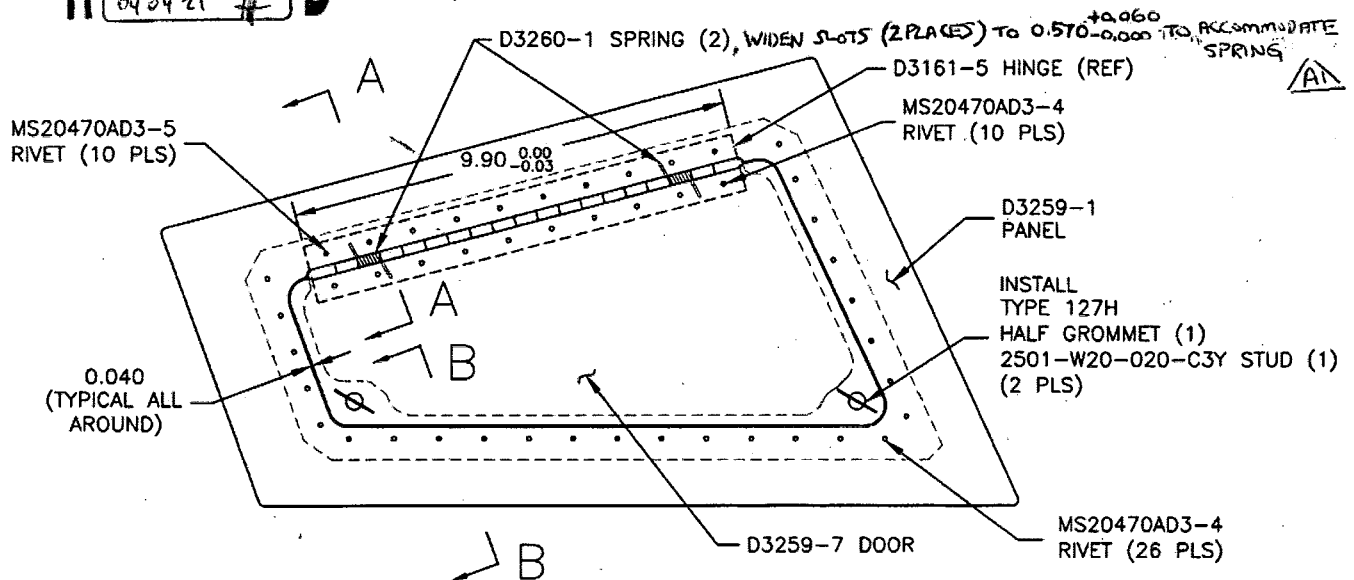
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	RF	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3259
				REV. A SHEET 1 OF 6
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	SCALE 1:4
A	04.02.25	NEW ISSUE		
A1	CP # 04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING		

RELEASED  
040421 #



**SECTION B-B**  
VIEW ROTATED

**SECTION A-A**  
VIEW ROTATED

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WORK ORDER  
NO 44236

**D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)**  
**D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)**

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

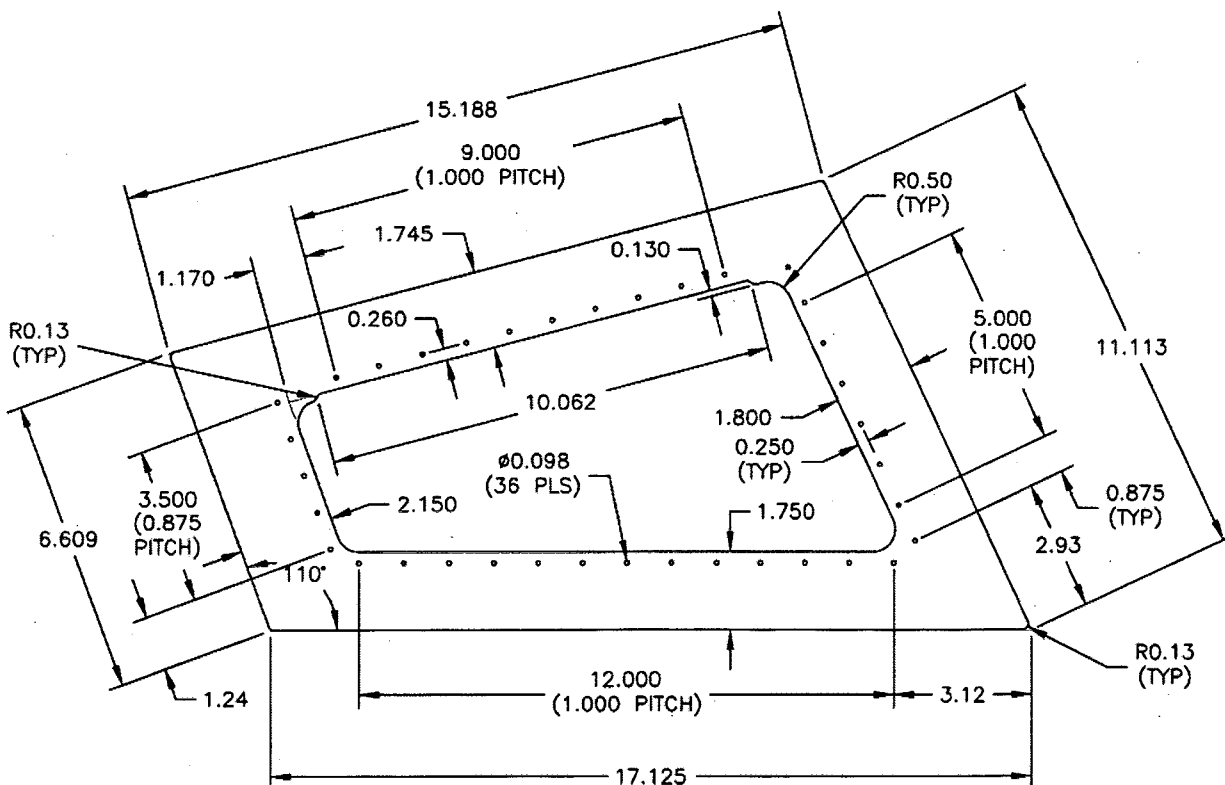
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04.04.05



**D3259-1 PANEL**

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 214236

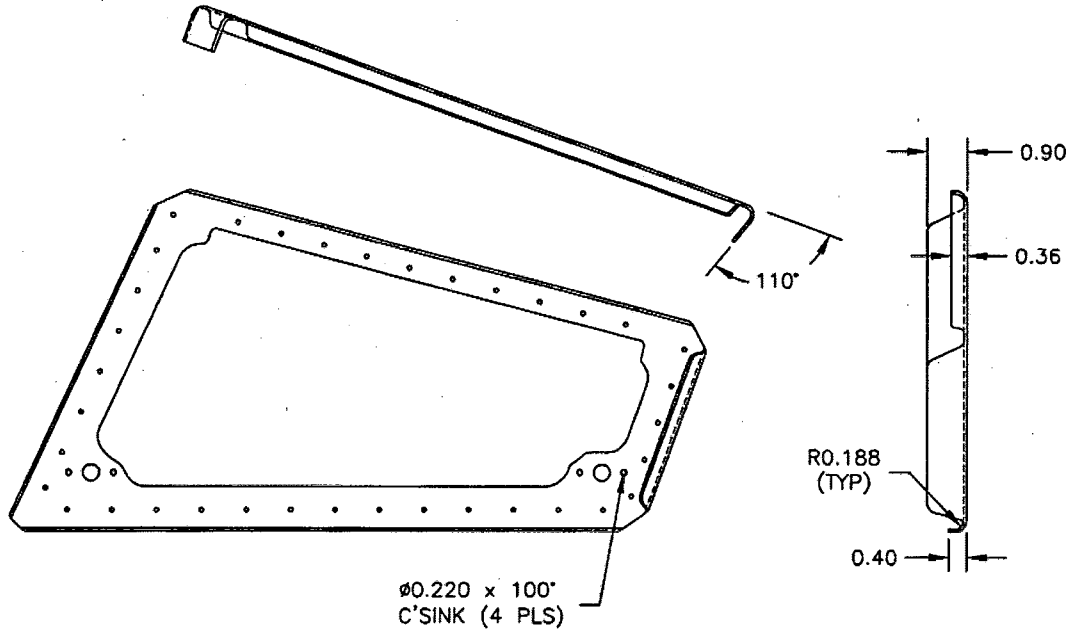
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

**RELEASED**  
04.04.14**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

**D3259-3/-4 NOTES:**

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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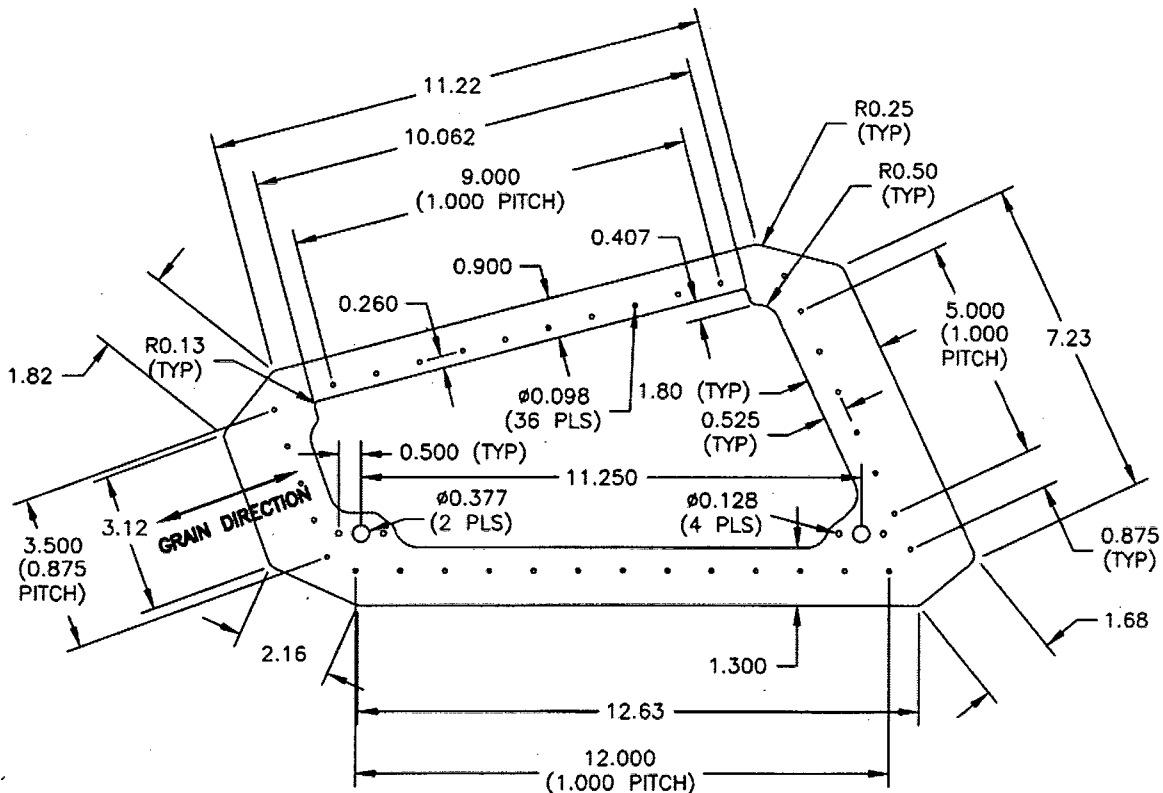
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
010914



**D3259-3/-4 DOUBLER FLAT PATTERN**  
( $\phi 0.098$  HOLES TO COINCIDE WITH HOLES IN D3259-1)

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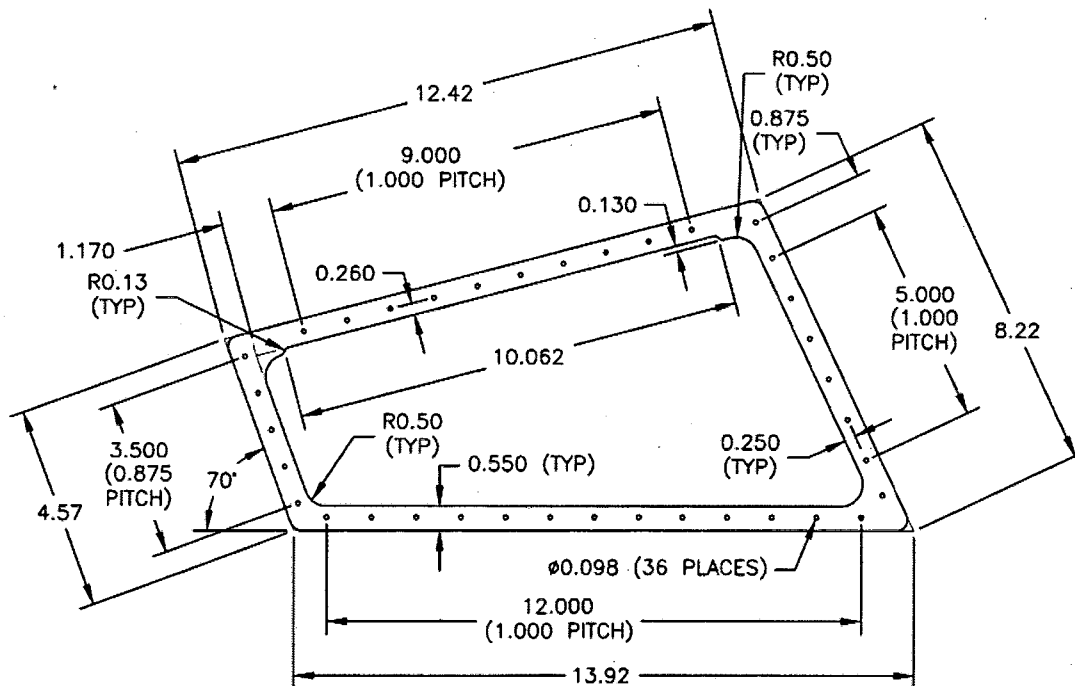
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED  
04.04.05 [Signature]



### D3259-5 SPACER

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

#### NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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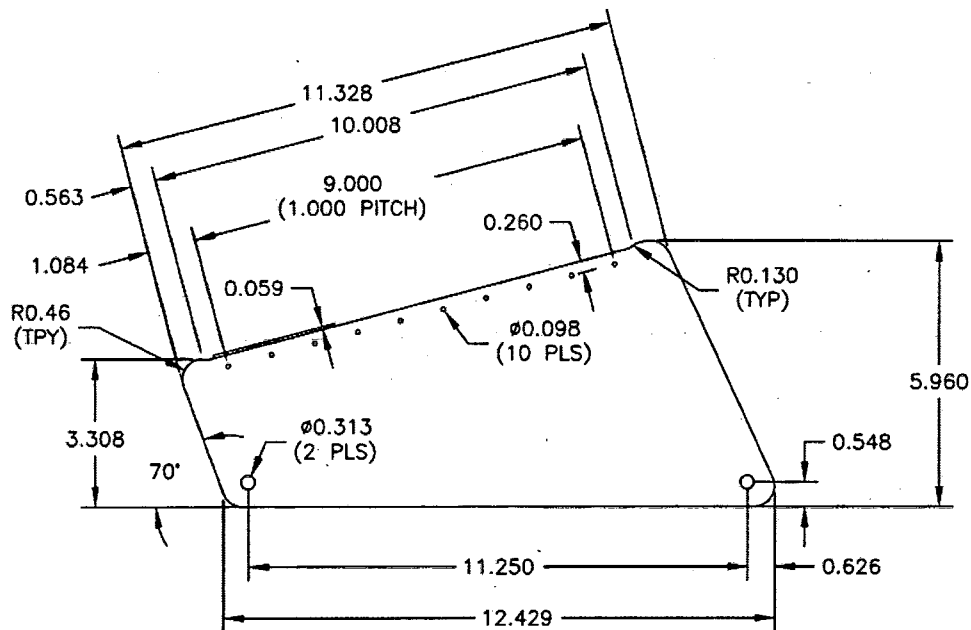
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

**RELEASED**  
04.04.14 **D3259-7 DOOR****NOTES:**

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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